

Work Order ID 148276

Tuesday, June 28, 2016 9:00:01 AM

148276

Page 1

Item ID: D2332-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lid Prop Assembly 6.69"

Start Date: 6/20/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00

100

Small Fab

Small Fab

Memo

0.11

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

4 FF JUL 12 2016

110

0.00

110

Brake NC

Brake NC

Memo

0.06

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

4 FF JUL 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120						4	FF		JUL 12 2016
Small Fab	Memo	0.09							
Small Fab	1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)								
	2- Ensure no foreign objects inside tube								
	3- Deburr								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.01							
Quality Control									JUL 14 2016
140		0.00							
140						4	2	16-7/19	
Large Fab	Memo	0.07							
Large Fab	Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)								
	*****ensure nothing is inside of tube before welding*****								
	S.S Rod batch: <u>M 123823</u>								

DQA: _____ Date: _____



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148276

Tuesday, June 28, 2016 9:00:01 AM

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.01

Quality Control

DAS
9
9-89

160

QC5- Inspect part completeness to step on W/O

0.00

160

OC

Memo

0.01

Quality Control

DAS
9
9-89

170

0.00

170

Small Fab

Memo

0.05

Small Fab

1- Tumble

2- Assemble as per dwg D2332

JUL 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.01							DAS 38 JUL 29 2016
Quality Control									
190	Identify as per dwg & Stock Location: 81-367	0.00							
190									
Packaging	Memo	0.01							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.07							DAS 21 9-09 AUG 04 2016
Quality Control									

SA 7/29/16

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Picklist Print

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Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

Start Date: 6/20/2016

Required Date: 6/27/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-4A		Purchased		No		170	Each	142.0000	1	4			
--------	--	-----------	--	----	--	-----	------	----------	---	---	--	--	--

AN4-4A

BOLT

FF JUL 29 2016

Location	Loc Qty	Loc Code
FP001	2	
m125709	2	
ST346	140	
m129390	140	

M304R.250

Purchased

No

100

f

14.3872

0.1

0.421053

M304R 250

304 SS Round bar .250

FF JUL 12 2016

Location	Loc Qty	Loc Code
MAT	9.353838	
m133368	9.353838	
MAT028	5.033394	
122682	5.033394	

M304TR0.500W.035

Purchased

No

110

f

166.7662

1.25

5.263158

M304TR0 500W 0.35

304 RD Tube .500 x .035W

FF JUL 12 2016

Location	Loc Qty	Loc Code
GA	15.45679	
m133509	15.45679	
GA002	151.3094134	
m128495	2.81737	
m132775	0.27	
m132872	1.6822064	
m133611	3.994895	
m134504	142.544942	

5.263158

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, June 28, 2016 9:00:01 AM

Page 2

Work Order ID: 148276

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

148276

D2332-041

Start Date: 6/20/2016

Required Date: 6/27/2016

Start Qty: 4.00

Required Qty: 4.00

M304TR1.000W.049

Purchased

No

100

f

63.3767

0.43

1.810526

M304TR1 000W 049

304 RD Tube 1.00 x .049W

FF JUL 12 2016

Location

Loc Qty

Loc Code

GA002

63.376705

125250

44.182931

m130551

19.193774

1.810526

MS21042L4

Purchased

No

170

Each

1,993.000

1

4

MS21042L 4

Locknut

FF JUL 29 2016

Location

Loc Qty

Loc Code

GA

161

m133769

161

OVER007

500

m134955

500

ST303

1238

m127376

12

m134861

726

m135058

500

ST305

94

m130922

94

4

NAS1149D0416J

Purchased

No

170

Each

3,977.000

3

12

NAS1149D0416.J

WASHER

FF JUL 29 2016

Location

Loc Qty

Loc Code

GA

121

m131511

121

ST260a

1984

m131511

1984

ST264

1872

m131511

1872

12

Tuesday, June 28, 2016 9:00:01 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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								Lead hand / Supervisor Approval Verification																																																																	
								QC / QA Coordinator Approval																																																																	
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DART AEROSPACE LTD	Work Order: 148 276
Description: Lid Prop Ass 6.69"	Part Number: D2332-041
Inspection Dwg: D2332 Rev: C1	Page 1 of 1

Work Order:

148 276

Description:

Lid Prop Ass 6.69"

Part Number:

D 2332-041

Inspection Dwg:

Rev: C1

Page 1 of 1

INSPECTION SHEET

DAS

30

9-89

Measured by:

FF

Checked by:

JUL 12 2016

QC Inspector:

Date:

JUL 12 2016

Date:

Date:

Engineering Approval:
(If necessary)

Date:

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Date _____

Change

New Issue

Revised by

KJ

Approved